

**WHAT IS CLAIMED IS:**

1. A multi-layer, bioriented film stretched in the machine direction and in the transverse direction, said film comprising
  - (a) a base layer comprising polyethylene and a cavitating agent, said base layer having a first and second side; and
  - 5 (b) skin layers on said first and second sides of said base layer, wherein at least one of said skin layers comprises (i) a hydrocarbon resin and (ii) a copolymer of ethylene and at least one monomer having at least three carbon atoms.
- 10 2. A film according to claim 1, wherein said copolymer (ii) is an ethylene-propylene copolymer or an ethylene-propylene-butylene terpolymer.
3. A film according to claim 1, wherein said hydrocarbon resin is selected from the group consisting of a petroleum resin, a terpene resin, a styrene resin and a cyclopentadiene resin.
- 15 4. A film according to claim 1, wherein at least one of said skin layers comprises from about 10 to about 20 wt% of said hydrocarbon resin (i) and about 80 to about 90 wt% of said copolymer (ii).
5. A film according to claim 1, comprising at least one tie layer comprising polyethylene.
- 20 6. A film according to claim 1 having a WVTR of at least 3.0 grams/100 square inches/day at 38°C and 100% relative humidity.
7. A film according to claim 6, wherein said polyethylene in said base layer (a) is high density polyethylene or medium density polyethylene.

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8. A film according to claim 7, wherein said cavitating agent is calcium carbonate and said base layer comprises from about 3 wt% to about 15 wt% of said calcium carbonate.

9. A film according to claim 8, wherein said base layer has a porosity of at least 20%, and wherein said film has unidirectional tear properties in the machine direction.

10. A method for making the film according to claim 1, said method comprising the steps of:

- (i) coextruding layers having the composition of said layers (a) and (b);
- (ii) casting said coextruded layers of step (i) over a casting roll;
- (iii) stretching said cast film of step (ii) in the machine direction; and
- (iv) further stretching said stretched film of step (iii) in the transverse direction,

15 wherein said skin layer (b) is on the casting roll side of the film.

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